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D350-607-541
Job Sheet 166577



Part No: D350-607-541

Job Qty: 1 ea

Part Name: AS350/AS355 Quick Release Heli-Utility-Basket™ Long, Heavy Duty Lid



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 10/12/17

Job Tracking No:

Due Date: 11/10/17

Created By: Mario Poulin

Type: Stock

Description:

Customer: Heliswiss Iberica SA (CHELI02)

Hangar 4, Lado Norte, Aeropuerto De Sabadell, Barcelona Sabadell, , 08205 Spain ph:011 34 93 720 6090
fx:34-937-100130.

Note: DWG REV E SHEET 22 IPP REV:A 10-08-19 AS PER REV.A DD VERF BY:EC IPP Rev:B 11.02.09 add to install label DD verf by:EC IPP REV:C 12.03.06 AS PER ECN12-535 DD VERF:EC IPP REV:D 12.07.24 AS PER ECN 12-610 DD VERF:EC IPP REV:E 13.08.21 CHG005 / ECN 13-624 DD VERF:JLM IPP REV:F 14.06.09 AS PER ECN14-572 DD VERF:JLM IPP REV:G 16.09.12 added note at seq120 PAR16-515 DD VERF:JLM

Ship Via:

Bill of Materials

Part/Part Name	Part Note	Serial No	Quantity	Location
D350-607-541 AS350/AS355 Quick Release Heli-Utility- Basket™ Long, Heavy Duty Lid	DWG REV E SHEET 22 IPP REV:A 10-08-19 AS PER REV.A DD VERF BY:EC IPP Rev:B 11.02.09 add to install label DD verf by:EC IPP REV:C 12.03.06 AS PER ECN12-535 DD VERF:EC IPP REV:D 12.07.24 AS PER ECN 12-610 DD VERF:EC IPP REV:E 13.08.21 CHG005 / ECN 13-624 DD VERF:JLM IPP REV:F 14.06.09 AS PER ECN14-572 DD VERF:JLM IPP REV:G 16.09.12 added note at seq120 PAR16-515 DD VERF:JLM	F165539	1.000	FG095
AN310C4 Nut		FM138118	9.000	ST331
AN4-13A Bolt			0.000	
AN4C15 Bolt		F0000475	19.000	SUSPECT
D2690-6 Lanyard	DWG REV B2 IPP: C C 03.04.04 Reformat; Incorporated D2690-X KJ/RF	F165239	9.000	ST009
D350-607-511 AS350/AS355 Quick Release Basket/Long Cargo Tube Mounting Provisions, P3912-041 Eyebolt Receiver Assembly	DWG REV E IPP REV:A NEW ISSUE 10-06-28 JLM VERIFIED BY: LL IPP REV:B 13.12.30 PER RE.C ECN13-672 DD VERF:RQ IPP REV:C 14.06.09 AS PER ECN14-572 DD VERF:JLM	F165534 F166223	1.000 3.000	FG128 FG128
	DWG REV B IPP RevA: new issue DD 09.11.18 verified by:EC IPP Rev:B 10.06.10 memo in seq110 ***IF PLUNGER GOES IN TO DEEP, INSTALL A WASHER (AN960C516L) IF NECESSARY BETWEEN PLUNGER AND D3912-1. YOU MAY HAVE TO ENLARGE WASHER HOLE FOR IT TO FIT*** DD verf:JLM IPP REV:C AS PER REV B 10-08-05 JLM VERIFIED:DD	F165548	3.000	ST055
D4030-041 Long Basket Assembly (350)	DWG REV D SHEETS 1,3,4 IPP Rev:A new issue DD 10.03.23 verified by:EC IPP Rev:B as per dwg revB DD 10.04.20 verified by:EC IPP Rev:C as per dwg revC DD 10.08.18 verified by:EC IPP Rev D 12.03.27 per NCR12-1239 EC verified by:JLM		0.000	
D4086-200 Placard, Max Load	DWG REV C IPP REV:A NEW ISSUE 10-08-09 JLM VERIFIED BY:LL	F162774	4.000	ST075
D4150-041 Attachment Arm Assembly	DWG REV B IPP Rev:A 10.06.24 new issue DD verf:EC IPP Rev:B 10.07.22 as per revB DD verf:JLM	F165650	3.000	ST081
D4151-041 Basket Fwd Hardpoint Assembly, Lower	DWG REV C SHEET 1 IPP Rev:A 10.06.24 new issue DD verf:EC IPP Rev:B 10.07.22 as per revB DD verf:JLM IPP Rev:C 11.01.21 as per dwg revC DD verf:JLM	F165577 F164453	4.000 2.000	ST082 ST083

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabelled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER : _____					

D4151-243	DWG REV C SHEET 1 IPP Rev:A 10.06.24 new issue DD verf:EC IPP	F165241	4.000	ST090A
Basket Fwd Hardpoint	Rev:B 10.07.22 as per revB DD verf:JLM IPP Rev:C 11.01.21 as per dwg	F165736	1.000	ST083
Assembly, Upper	revC DD verf:JLM			
D4917-300	DWG REV B IPP REV:A 13.12.31 NEW ISSUE DD VERF:RQ	F164012	1.000	ST126
Placard, Max Load				
MS17984-C413		FM138209-9	9.000	ST315
Quick Release Pin		FM138414-43	5.000	OVER005
MS21042L4		FM133363-40	20.000	FP001
Nut		FM137988-2	80.000	ST328
		FM138230-2	500.000	OVER007
		FM138326-1	489.000	ST303
MS24665-151		FM128401	60.000	GA
Cotter Pin		FM138045-45	36.000	ST289
NAS1149C0463R		FM127306-15	24.000	FP001
Washer		FM137736-15	136.000	ST266
NAS1149F0432P		FM138230-25	335.000	ST262
Washer		FM134376	84.000	ST260
NAS1515H4L		FM138237-25	71.000	ST260
Washer				

Job Routing

Op No	Operation	Qty	Due Date	Standard		Workcenter/Supplier	
				Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time
90	Start up Operation	1 Ea	11/10/17	0.00	0.00	Start up container	
100	DC	1 pcs	11/10/17	0.00	0.00	DC	
110	Packaging	1 pcs	11/10/17	0.00	0.00	Packaging1	
120	QC	1 pcs	11/10/17	0.00	0.00	QC4	
130	Packaging	1 pcs	11/10/17	0.00	0.00	Packaging3	
140	QC21-FG	1 Ea	11/10/17	0.00	0.00	QC21	

Part Op 100 - Photocopy bluefile & type labels per PPP D350-607-541 CHG007
 Descriptions: 130 - Package as per PPPD350-607-541

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9-89 NOV 16 2017

Job Allocations

Operation	Component Part	Required	Inventory	Allocated	Std Qty
90-Start up Operation	✓ AN310C4 5009608	1	9	0	0
	✓ AN4-13A 5009607	6	20	0	0
	✓ AN4C15 5009606	1	19	0	0
	✓ D2690-6 5009590	1	9	0	0
	✓ D350-607-511 166223	1	4	0	0
	✓ D3912-041 165548	1	3	0	0
	* ✓ D4030-041 5009630	1	0	0	0
	✓ D4086-200 5009517	1	4	0	0
	✓ D4150-041 165650	1	3	0	0
	✓ D4151-041 5009513	1	4	0	0
	✓ D4151-043 164453	1	7	0	0
	✓ D4917-300 5009503	1	1	0	0
	✓ MS17984-C413 5009499	1	14	0	0
	✓ MS21042L4 5009491	6	1,089	0	0
	✓ MS24665-151 5009439	1	96	0	0
	✓ NAS1149C0463R 5009427	3	160	0	0
	✓ NAS1149F0432P 5009483	12	335	0	0
	✓ NAS1515H4L 5009480	2	175	0	0

Part Specifications

Specifications could not be found.

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS				
Part No. _____		Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	
NCR No. _____		Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	
		Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	
		Large Fab ☐	Composite ☐	Supplier ☐		

Date : _____ Step #: _____ QTY Effective : _____ MRB (QSI042) Approval _____

Description : _____

Job No: 166577
Mfg Date: 11/14/17

Start up Operation

D350 - 607 - 541

AS350/AS355 Quick Release Heli - Utility - Basket Long,



Change No:

Operation:

Revision:

PART NO:

Heavy Duty Lid

DART
AEROSPACE
S009712

Completed By _____

Lead hand / Supervisor
Approval Verification _____QC / QA Coordinator
Approval _____**Root Cause**

Environment ☐	No Re-verification ☐
Design ☐	Operator ☐
Doc/Data ☐	Offset/Setup ☐
Equip/Tooling ☐	Supplier ☐
Handling/Pre ☐	Training ☐
Material ☐	Use for Testing ☐
Internal Transport ☐	Poor Information ☐
Tribal Knowledge ☐	Rushing ☐
LOA ☐	Product Improvement ☐
Substation ☐	Process Improvement ☐
Past Expiry Date ☐	Manufacturing Process ☐
Misidentified ☐	Past Due ☐

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Cuts

Crushing

Heat Treat

Wave/Twist in Tube

Marks/Chatter

OTHER : _____

Contamination

Countersink

Cut Too Short

Instructions Incomplete/Unclear

Drill Holes

Out of Sequence

Off-set

Mislabeled

Fit/Function

Misaligned/off center

Positioned Wrong ☐
 Outside Dimensions ☐
 Over/Under tolerance ☐
 Part Incorrect ☐
 Part Lost/Missing ☐
 Part Moved ☐
 Drawing ☐
 Finish ☐
 Misread ☐
 Turning Sequence ☐